

Work Order ID 68343 -2 *Split*

Tuesday, April 12, 2011 10:06:46 AM

Page 1

Item ID: D3405-043

Accept

Revision ID:

Item Name: Lug Assembly

Start Date: 4/12/2011 Start Qty: 10.00

Required Date: 4/18/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date: 11-04-12 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100



Waterjet

FLOW CNC Waterjet

3-4 128

FLOW WATER JET

Memo

1-Cut as per Dwg D3405

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

0.00

0.00

B11-4-27

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B11-4-27

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

*Subtotal*

*712*

# Work Order ID 68343

Tuesday, April 12, 2011 10:06:46 AM



Page 2

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 4/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Brake NC

Memo

0.00

1-Debur  
2-Form using DT8204 as per Dwg D3405  
3- use DT9681 to check if correct forming

SB 11/05/02

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/05/02

(H2)

150



Large Fab

Large Fab

Weld per dwg. A/R S.S. rod Batch: M107057  
Large Fab

0.00

Memo

0.00

Weld as per Dwg D3405 use DT8484  
Identify as D3405-043

E2 11-6-6 (28)

# Work Order ID 68343

Tuesday, April 12, 2011 10:06:46 AM



Page 3

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 4/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*Pl 11.06.07*

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sub 6/6/09*

*(x2)*

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10 = 10  
400 OF  
10 = 40*

*8x Ø m-L 11/06/13*

# Work Order ID 68343

Tuesday, April 12, 2011 10:06:46 AM



Page 4

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 4/12/2011 Start Qty: 10.00



Required Date: 4/18/2011 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 4 11/06/13

200

Identify as per dwg & Stock Location: 424

0.00



Packaging

Memo

0.00

Packaging

11/06/13 (8)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/14

11-06-13 (8)

# Picklist Print

Tuesday, April 12, 2011 10:06:52 AM

Page 1

Work Order ID: 68343

Parent Item: D3405-043

Parent Item Name: Lug Assembly



Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 05.09.01 New issue KJ/JLM  
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1 Manufactured No

100 Each 30.0000 1 10



GHW Lug



Q 11-6-6

69883 x 8

Location

Loc Qty

Loc Code

WA030

30

67127

30

M304S11GA

Purchased No

150 sf

6.0000

0.154

1.621053

2



304/316 0.125 Sheet



11-4-07

Location

Loc Qty

Loc Code

MAT020

6

116623

6

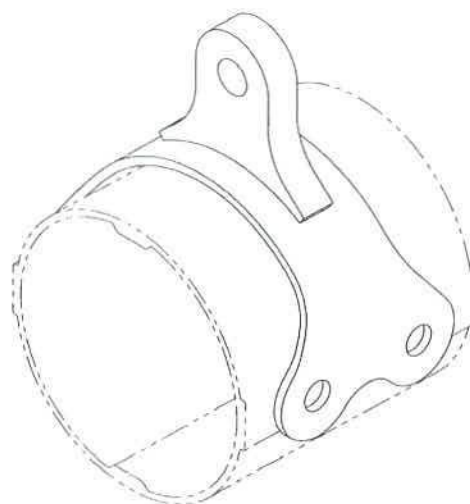
117494

12

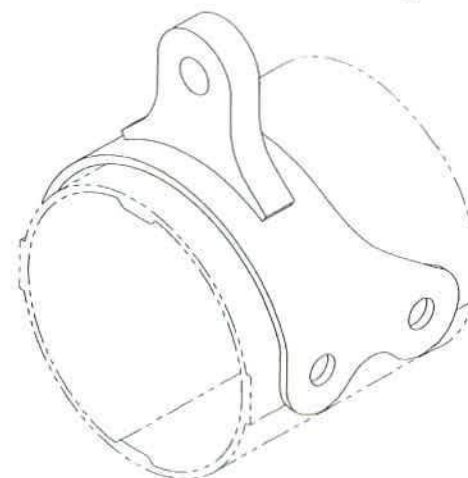




ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

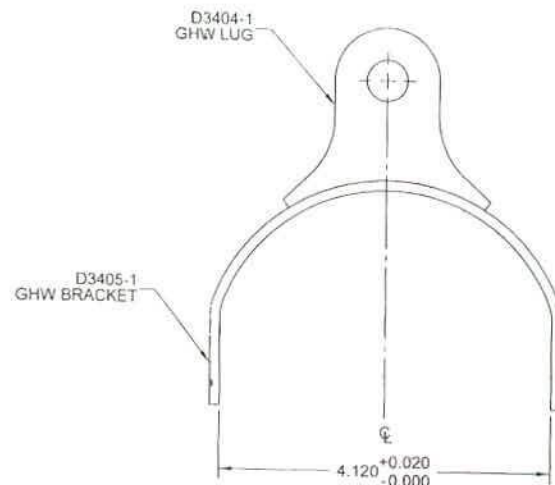
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

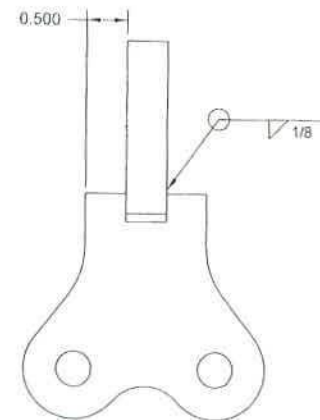
PHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48343  
PH 11-04-12

**RELEASED**  
08/12/18

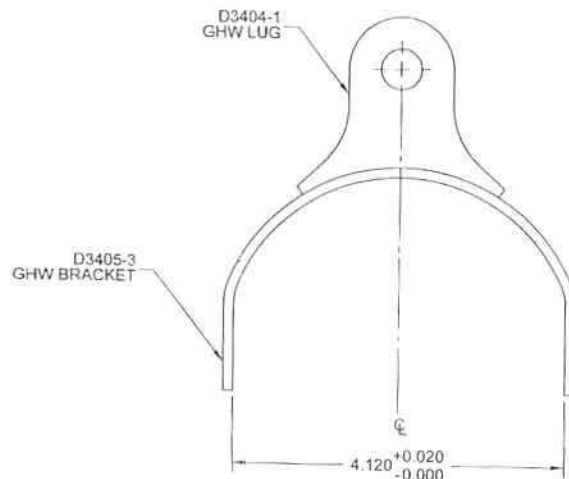
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR 196). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3405 TITLE GHW LUG ASSEMBLY SCALE NTS DATE 08.09.19		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR				



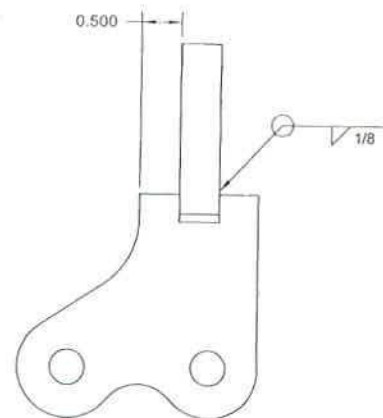
**D3405-041 LUG ASSEMBLY**



u/068343



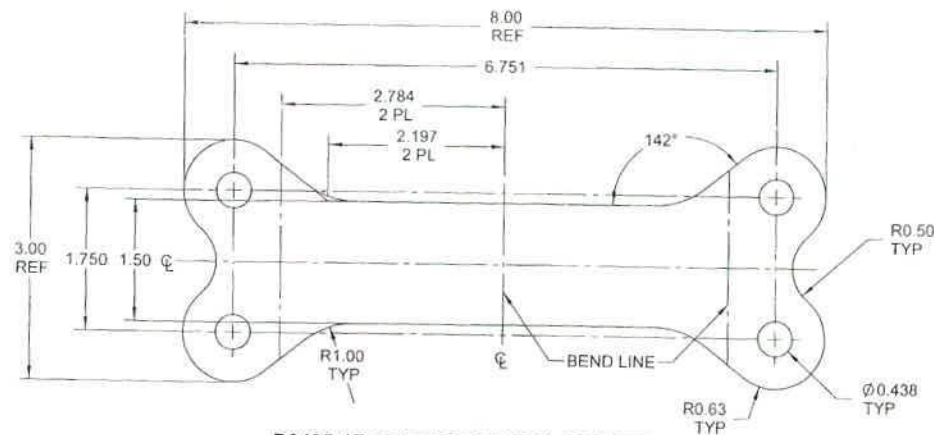
**D3405-043 LUG ASSEMBLY**



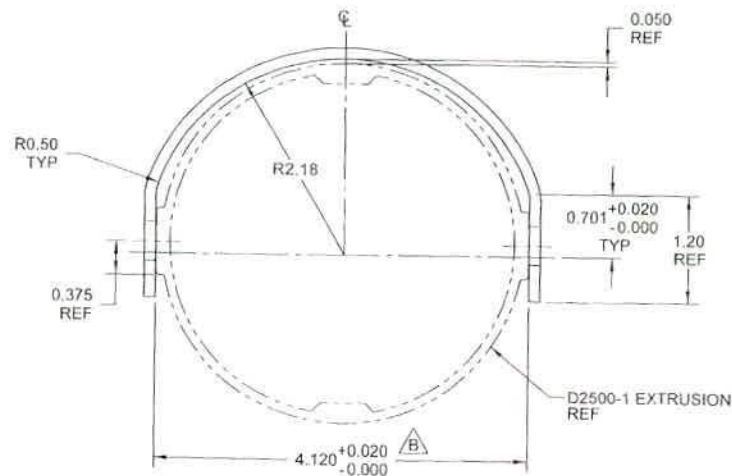
**RELEASED**  
08/12/18

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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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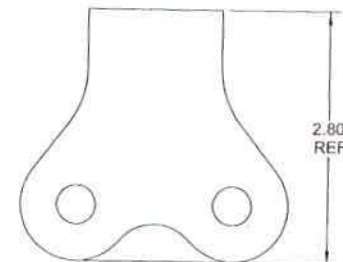




**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

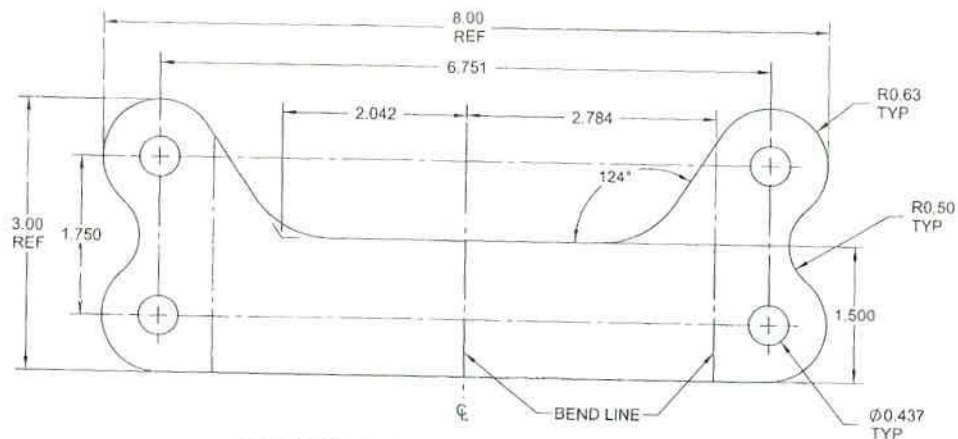
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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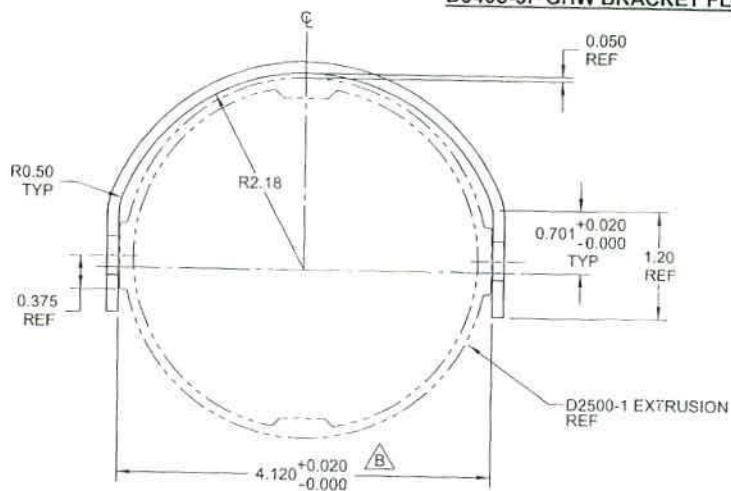
**RELEASED**  
MP 08/12/19

WLO 68343

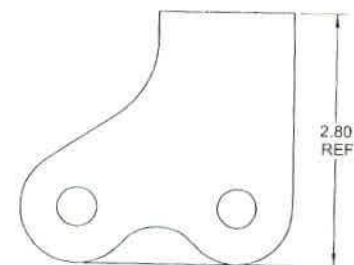


u10 48343

**D3405-3F GHW BRACKET FLAT PATTERN**



**D3405-3 GHW BRACKET**  
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
06/12/18

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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